

July 15

# Work Order ID 71041

Tuesday, June 21, 2011 1:14:12 PM



Page 1

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 6/21/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr								
D3413	Rev A								

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-6-30

FLOW CNC Waterjet

304 .250X 4:

1-Cut as per Dwg D3413  
Dwg Rev: 1  
Prog Rev: 1  
2-Deburr if necessary

(6)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

j1

B11-6-30

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

0.00 July 15/04

(74)

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71041**

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Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 &amp; QSI018 4.1.

6

140



QC5- Inspect part completeness to step on W/O

0.00

6

Quality Control

145



SprayPaint

Memo

0.00

Spray Painting

 PRIME B 117319  
 DELFLEET BLUE B 115985  
 DELFLEET CLEAR B 117113
6 11 07 13 6

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71041**

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Item ID: D3413-1

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Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

155



QC

Quality Control

Operation  
Description

QC14- Inspect Spray Paint

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

BT 11-07-14 (x6)

170



Packaging

Packaging

Identify as per dwg & Stock Location: *420*

0.00

*11/7/15 JF*

180



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/7/15 JF*
*MF 11-07-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 1:14:18 PM

Page 1

Work Order ID: 71041



Parent Item: D3413-1



Parent Item Name: Ring

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A □ 05.09.13 □ New issue □ KJ/JLM  
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000  304 BAR .250 x 4.00		Purchased		No		100	f	8.2000	0.25	1.578947		B11-6-30	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	8.2	
116808	8.2	

116808

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71091
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-6-20	Date: 11/07/04	Date: N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.09.06	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

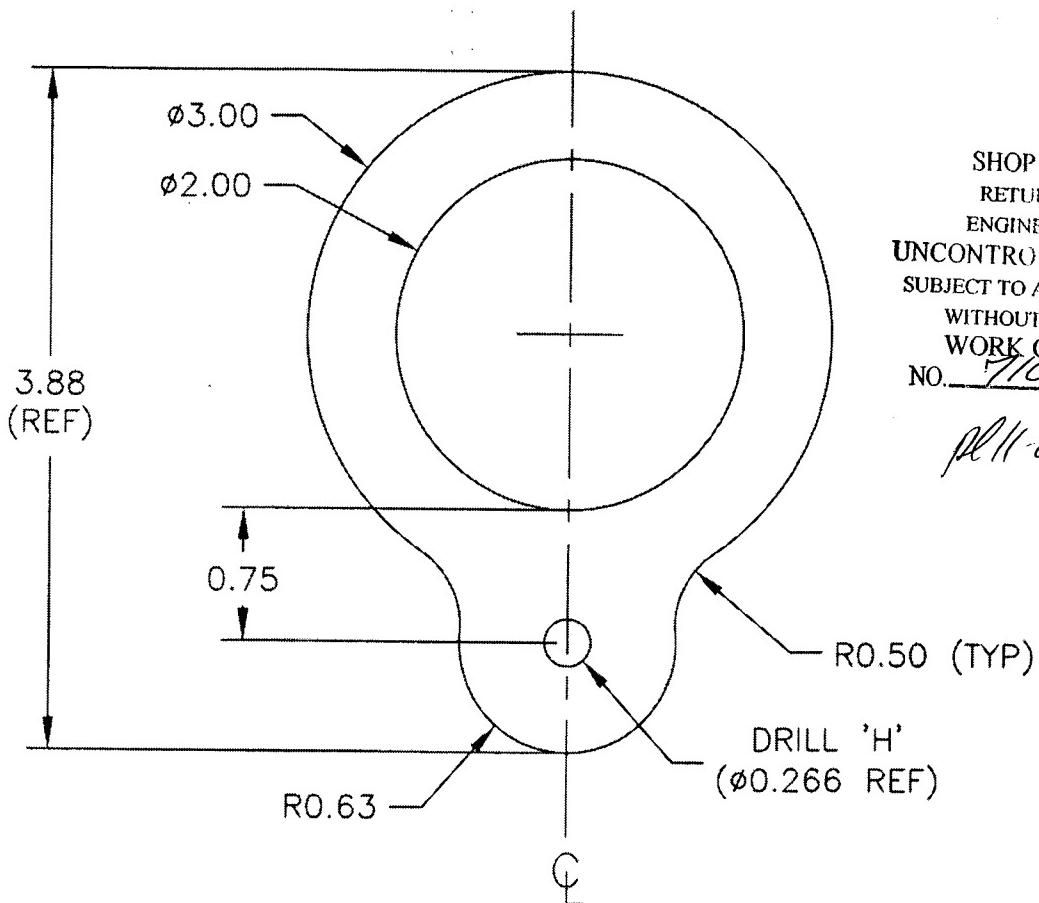
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413
DATE 05.03.16		REV. A SHEET 1 OF 1
		TITLE RING
A	05.03.16	SCALE 1:1
		NEW ISSUE

RELEASED  
05-09-06 *[Signature]***D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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